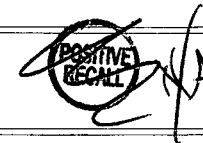


Work Order ID 117748

Thursday, May 01, 2014 10:35:35 AM

117748



Page 1

Item ID: D412-694-01

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Door Assembly, LH

Start Date: 5/1/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/22/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D412-694

Rev C1

100

Document Control

0.00

100

DOCUMENT CONTROL

0.00

DC

Memo

Doc.Control -USB or Paperwork

Issue red decal labels for D412-694-01

CHG005

P13

Work Order ID 117748

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117748

Page 2

Item ID: D412-694-01

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Door Assembly, LH

Start Date: 5/1/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/22/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00

110

COMPOSITE ASSEMBLY

Small Fab

Memo

0.00

Small Fab

D412-694-01 Drill Process

1- Drill (7) holes using Ø(#40) drill. Drill (3) holes top/bottom Ø(#40) for insert (do not pass thru) using B30-23000-01 as per Dwg D412-694 page 4 (view P).

2- Open (1) hole to 11/16" (0.688) for the handle using unibit. Transfer (4) Ø(#30) holes from D3151-041 to the door and c'sink from far side for the rivet. Transfer (2) holes Ø(3/16") for MS24694-C5 screw as per Dwg D412-694 page 4 (view P).

Note: D3151-041 orientation in the door.

3- Open (3) holes Ø(#19) or (0.166) top/bottom of the door and c'sink Ø0.300 x 100° from the far side and D3155-041/-042 bracket assembly as per Dwg D412-694 page 4 (view P).

4- Drill Ø(#30) holes using drill Jig D3144-T1 for the doublers. Drill (2) holes in two places Ø 3/16" (0.188) for the slot opening. Router slot using D3144-T2/-T3 as per Dwg D412-694 page 2.

Note: The (12) holes for the (6) nut plates can not be less than 0.290" from inside edge.

5- Open (3) holes to Ø37/64" (0.578) at top/bottom insert for D3163-041 cover assembly as per Dwg D412-694 page 4 (view P). Drill Ø(#30) outer door handle as shown in view Z-Z page 2. Open holes to Ø0.257.

6- Drill Pilot holes Ø(#1/8") for rollers using drill Jig DT8703-1. Use unibit to open holes to Ø 37/64" (0.578) for inserts as per Dwg D412-694 page 2, page 6 (view K, L, M, Q).

 14-12-08

DQA: 15/05/08 Date: 15/05/08

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: 15/04/08 Date: 15/04/08Work Order update only ☐

Work Order: <u>117748</u>	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. <u>D412-694-01</u>	Rework <input checked="" type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	
NCR No. <u>15-4841</u>	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input checked="" type="checkbox"/>	Supplier <input type="checkbox"/>		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	14-12-08	110	1	D3163-041 when installed AP overhangs Fwd edge by 0.300"	14.12.12	use D3163-042 cover instead it fits properly	14-12-08	DAS 38 9-89	DAS 9 9-89
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread	<input checked="" type="checkbox"/> Other
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set	
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration	
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence	

DQA: Aut Date: 15/05/05

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: DM Date: 15/04/30Work Order update only ☐

Work Order: <u>117748</u> Part No. <u>D412-694-01</u> NCR No. <u>15-4841</u>	DISPOSITION Rework <input checked="" type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input checked="" type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input checked="" type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input checked="" type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design		14-12-15	110	x1	D3162-043 moved when transfer drilling causing face of nut plate to stick 0.125 above face of door (supposed to be flush) P.c. operator and process	A.P. 14.12.15	scrap + replace D3162-043 <u>B 126076</u>	ET 14-12-10	DAS 38 9-89 14-12-19	DAS 9 9-89 14-12-23
Doc/Data										
Equip/Tooling										
Handling/Pre										
Material										
Operator	*									
Offset/Setup										
Process	✓									
Supplier										
Training										
Transport										
Unapproved										

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input checked="" type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		
<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

DQA: At Date: 13/05/05

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: 15/04/30 Date: 15/04/30Work Order update only ☐

Work Order: <u>117748</u>	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. <u>D412-694-01</u>	Rework <input checked="" type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	
NCR No. <u>15-484</u>	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input checked="" type="checkbox"/>	Supplier <input type="checkbox"/>		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design Doc/Data	14-12-23	110	x2	M551859-7 id too small, hard to open up id	A.P. 14.12.23	use M551859-8 turn down O.D. using DT 10079 on manual lathe to 0.710"	AK 14-12-23	DAS 9 9-89 14-12-23	DAS 9 9-89 14-12-23
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread	<input checked="" type="checkbox"/> Other
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set	<u>Fit issue</u>
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration	
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence	

Work Order ID 117748

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117748

Page 3

Item ID: D412-694-01 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Door Assembly, LH
Start Date: 5/1/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/22/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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7- Drill Pilot holes Ø(#1/8") for rollers using drill Jig DT8703-2. Use unibit to open holes to Ø 37/64" (0.578) for inserts as per Dwg D412-694 page 2, page 6 (view H, J).

8- Drill (27) pilot holes Ø(#30) using drill Jig DT8703-3LH for D3126 brackets as per Dwg D412-694 page 2 (view G-G). Use unibit to open holes Ø37/64" (0.578) for inserts.

9- Drill (2) Pilot holes Ø(#30) by transfer from D3152-041 bracket. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 6 (view Q).

10- Drill (12) Ø(#30) holes from the edge of the door to opposite side for D3162-041 bracket using a long drill and keep drill perpendicular. Ensure (4) holes used from the center of the hole to top and bottom edge of the thick section of D3163-041 cover assembly. Compare hole depth with rivet in the foam as per Dwg D412-694 page 4 (view P) and (view R-R/-S-S). Drill (8) Ø(#30) holes from the edge of the door using a long drill and keep drill perpendicular. About the (4) last holes around the small square of the cover, take the measurement 0.250" from each corner of the D3163-041 cover.

120

0.00

120

COMPOSITE ASSEMBLY

Small Fab

Memo

0.00

Small Fab

1-Install inserts as per Dwg D412-694 page 2 (view G-G); page 6 (view H, J, L, M, Q).

2- Sand flush excess Hysol around the insert on both doors.

8 14 12 09

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Page 4

Setup Start *NS1*

Stop *NS2*

Customer:

Run Start *NR1*

Stop ***NR2***

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

[illegible]

Work Order ID 117748

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117748

Page 5

Item ID: D412-694-01 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Door Assembly, LH
Start Date: 5/1/2014 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 9/22/2014 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

160

Small Fab

Small Fab

COMPOSITE ASSEMBLY

Memo

D412-694-01 Assembly Process

1- Install D3162-041 as per Dwg D412-694 page 4 (view R-R/S-S) and D3156-1 bracket as per (view T-T/U-U). Open holes to #30 (0.128) for rivet and alodine the open holes.

Note: Start installation window side. Wait to fix D3162-041/-043.

2- Install D3151-041 Doubler as per Dwg D412-694 page 4 (view P).

3- Connect D3132-041 Rod Weldment with D3122-1 Lever and D3133-041 Rod Weldment as per Dwg D412-694 page 4 (view P).

4- Assemble D3123-1 Cam with D3124-1/-2 Hook with D3155-041/-042 Bracket Assembly as per Dwg D412-694 page 4 (view P).

5- Install D3203-1 handle with D3308-1 doubler as per Dwg D412-694 page 2 (view Z-Z).

6- Install D3155-041/-042 Bracket Assembly and D3110-5 Handle as per Dwg D412-694 page 4 (view P) and page 2. Adjust rod weldment until everything works properly and looks in place.

0.00

0.00

85 14-12-18

Work Order ID 117748

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117748

Page 6

Item ID: D412-694-01

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Door Assembly, LH

Start Date: 5/1/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/22/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

2

DAS
38
9-89

14-12-19

Work Order ID 117748

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117748

Page 7

Item ID: D412-694-01

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Door Assembly, LH

Start Date: 5/1/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/22/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

0.00

180

COMPOSITE ASSEMBLY

Small Fab

Memo

0.00

Small Fab

D412-694-01 Assembly Process (Continued)

1- Install D3116-7-0680 Seal and doublers. Transfer slot opening in the seal as per Dwg D412-694 page 2 (view V-V and N).

Note: If this is the D412-694-013, wait until the VIP trim is fixed on the door.

2- Install D3110-5 Handle Assembly in the D3163-041 Cover Assembly. Ensure Handle works freely. Ensure D3163-041 cover assembly is aligned with the door edge on both sides and D3110-5 Handle works properly.

3- Transfer the holes to the cover with the hole finder. EXCEPTION: the (4) holes are around the handle. Install the bracket with the holes from the small square of the cover (Ø0.250")

4- Open 15/64" (0.234) holes to D3163-041 cover assembly and D3135-041 handle weldment. Transfer D3139-1/-3 guard holes in cover assembly and drill holes for nutplate. Deburr and touch up holes with alodine as per Dwg D412-694 page 2.

5- Install MS21072-L3 Nutplate and Guard as per Dwg D412-694 page 2.

6- Transfer (#30) holes from D3144-13 doubler to seal and door. Ensure D3116-9-0770 is properly aligned as per Dwg D412-694 page 2 (section NN-NN). Apply 732 RTV Clear (A/R) in the hole prior to installing rivet and then in the rivet head after installation.

A/R RTV732 Clear Batch: 131036 Expiry Date:16-12-11

7- Install D3126 Brackets and D3138-1 Cover as per Dwg D412-694 page 2

81 14-12-16

Work Order ID 117748

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117748

Page 8

Item ID: D412-694-01 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Door Assembly, LH
Start Date: 5/1/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/22/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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(view G-G and NN-NN).

8- Install and assemble brackets as per Dwg D412-694 page 2 and 5 (view H, J, L, M and Q).

190

QC5- Inspect part completeness to step on W/O 0.00

190

QC

Memo

0.00

Quality Control

Install door on mock up helicopter to insure proper fit and function

DAS
38
9-89

14-12-19

200

COMPOSITE ASSEMBLY

0.00

200

Small Fab

Memo

0.00

Small Fab

1- Finish installing D3163-041 in the door.
2- Install red decal before closing cover.DAS
38
9-89

14-12-18

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Page 9

6/4/224

Picklist Print

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Page 1

Work Order ID: 117748

117748

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: A 05.12.09 New Issue KJ/RF
IPP Rev: B 06.04.18 New dwg rev. ecn781 EC
IPP Rev: C 06.07.11 Revised per B24660 KJ
IPP Rev:D 08-08-27 replace QC5 to QC14 seq.7 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
80-005-2-8		Purchased	No			160	Each	270.0000	55	55			
80-005-2-8									**	129790		DAS	
Insert												06	
												9-89	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST380		270							
				113109		23							
				120273		47							
				121500		100							
				122661		100							
AN525-10R6		Purchased	No			160	Each	96.0000	12	12			
AN525-10R6									**	130325		DAS	
Screw												06	
												9-89	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST344		96							
				M127743		96							
AN525-10R7		Purchased	No			160	Each	1,465.000	8	8			
AN525-10R7									**	14130		DAS	
SCREW												06	
												9-89	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST344		2							
				m127447		2							
				ST505		1463							
				m127815		713							
				m128429		750							

NOV 29 2014

Picklist Print

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Page 2

Work Order ID: 117748

117748

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

BSP45 Purchased No 160 Each 477.0000 79 79

RSP45

Commercial Rivet

Location

Loc Qty

Loc Code

ST282

477

120417

477

130851

DAS
36
9-89

BSP46 Purchased No 160 Each 251.0000 6 6

RSP46

Commercial rivet

Location

Loc Qty

Loc Code

ST282

251

112540

251

6

DAS
6
9-89

D3110-5 Manufactured No 160 Each 1.0000 1 1

D3110-5

Handle Assembly

Location

Loc Qty

Loc Code

ST026

1

83229

1

14-12-08

DAS
6
9-89

D3115-1 Manufactured No 160 Each 2.0000 1 1

D3115-1

Bracket

Location

Loc Qty

Loc Code

ST026

2

82774

2

14-12-08

D3116-7 Manufactured No 160 f 485.0000 5.6666 6

D3116-7

Seal (\$Per Foot)

Location

Loc Qty

Loc Code

ST414A

485

65117

485

14-12-08

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Work Order ID: 117748

117748

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

D3116-9 Manufactured No 160 f 550.0000 6.4166 7

D3116-9

Seal (\$Per Foot)

**

DAS

06

9-89

Location

Loc Qty

Loc Code

ST414A

550

39182

550

160 Each

3.0000

3

3

**

DAS

06

9-89

Location

Loc Qty

Loc Code

ST235

3

101711

3

160 Each

0.0000

1

1

**

DAS

06

9-89

D3121-041 Manufactured No

D3121-041

Bracket Assembly

D3121-043

Manufactured No

D3121-043

Bracket Assembly

D3122-1

Manufactured No

D3122-1

Lever

**

DAS

06

9-89

Location

Loc Qty

Loc Code

ST027

3

65171

3

160 Each

212.0000

2

2

**

D3123-1 Manufactured No

D3123-1

Cam Assembly

Location

Loc Qty

Loc Code

Mezz

212

1053617

212

x2

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Work Order ID: 117748

117748

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

D3124-1 Manufactured No 160 Each 80.0000 1 1

D3124-1

Hook

DAS
06
9-89

Location

Loc Qty

Loc Code

CA

80

1053617

80

D3124-2 Manufactured No 160 Each 75.0000 1 1

D3124-2

Hook

Location

Loc Qty

Loc Code

ST027

75

1053617

75

D3126-1 Manufactured No 160 Each 10.0000 1 1

D3126-1

Bracket

DAS
06
9-89

Location

Loc Qty

Loc Code

ST027

10

105268

10

D3126-3 Manufactured No 160 Each 0.0000 1 1

D3126-3

Bracket

113689

DAS
06
9-89

D3126-5 Manufactured No 160 Each 2.0000 5 5

D3126-5

Bracket

124451

Location

Loc Qty

Loc Code

CA

1

36729

1

ST027

1

113560

1

NOV 29 2014

DAS
06
9-89

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Work Order ID: 117748

117748

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

D3132-041 Manufactured No

160 Each

27.0000

1

1

86
9-89

D3132-041

Rod Weldment B30-23000-14

**

Location

Loc Qty

Loc Code

Mezz

27

1053617

27

D3133-042 Manufactured No

160 Each

18.0000

1

1

D3133-042

Rod Weldment

**

Location

Loc Qty

Loc Code

CA

18

1053617

18

D3135-041 Manufactured No

160 Each

2.0000

1

1

D3135-041

Handle Weldment

**

Location

Loc Qty

Loc Code

ST236B

2

78748

2

D3137-045 Manufactured No

160 Each

3.0000

1

1

D3137-045

Bracket Assembly

**

Location

Loc Qty

Loc Code

ST235B

3

80099

3

D3138-1 Manufactured No

160 Each

1.0000

1

1

D3138-1

Cover Assembly

**

Location

Loc Qty

Loc Code

ST241A

1

78739

1

DAS
86
9-89

DAS
86
9-89

DAS
86
9-89

DAS
86
9-89

#107 62 AON

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Work Order ID: 117748

117748

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

D3139-1	Manufactured	No	160	Each	1.0000	1	1		DAS
D3139-1								**	126070
Guard									06 9-89

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
D3139-3	Manufactured	No	ST027	1					
			109457	1					
D3139-3								**	
Guard									DAS 06 9-89

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
D3140-05	Manufactured	No	ST027	3					
			96405	3					
D3140-05								**	
Door									
D3141-1	Manufactured	No		160	Each	0.0000	1	1	
D3141-1								**	14-10-22
Spring									

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
D3144-109	Manufactured	No	ST028	4					
			63507	4					
D3144-109								**	
Doubler									DAS 06 9-89

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
D3144-111	Manufactured	No	CA	3					
			50273	3					
D3144-111								**	
Doubler									14-12-08

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Work Order ID: 117748

117748

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

D3144-13	Manufactured	No	160	Each	3.0000	1	1
D3144-13			<i>B 124203</i>			**	<i>RT 14-12-08</i>
Doubler							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
CA	3	
67799	3	

D3144-3	Manufactured	No	160	Each	0.0000	1	1
D3144-3			<i>B 67800</i>			**	<i>RT 14-12-08</i>
Doubler							

D3148-1	Manufactured	No	160	Each	172.0000	2	2
D3148-1						**	<i>RT 14-12-08</i>
Clevis							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Mezz	172	
1053617	172	

D3151-041	Manufactured	No	160	Each	8.0000	1	1
D3151-041			<i>B 50294</i>			**	<i>RT 14-12-08</i>
Doubler Assembly							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
CA	8	
39186	8	

D3152-041	Manufactured	No	160	Each	1.0000	1	1
D3152-041			<i>128046</i>			**	<i>RT 14-12-23</i>
Bracket Assembly							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Mezz	1	
25284	1	

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Work Order ID: 117748

117748

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

D3162-044 Manufactured No

160 Each 10.0000 1 1

~~*D3162-044*~~

**

Bracket Assembly

Location

Loc Qty

Loc Code

ST031

10

36734

10

D3163-041 Manufactured No

160 Each 4.0000 1 1

~~*D3163-041*~~

**

Cover Assy

N/A as per P/O

Location

Loc Qty

Loc Code

ST178

4

101842

4

D3183-041 Manufactured No

160 Each 3.0000 1 1

~~*D3183-041*~~

**

Bracket Assembly

Location

Loc Qty

Loc Code

ST235B

3

102051

3

D3203-1 Manufactured No

160 Each 33.0000 1 1

~~*D3203-1*~~

**

Handle

Location

Loc Qty

Loc Code

ST240

33

108749

20

109418

10

89124

3

DAS
05
9-00

DAS
03
9-09

DAS
06
9-09

126533
NOV 29 2014
DAS
06
9-09

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Work Order ID: 117748

117748

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

D3308-1	Manufactured	No	160	Each	5.0000	2	2		
D3308-1						**		124372	
Doubler									
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST037	5					
			78712	5					
M7885/2-4-3	Purchased	No	160	Each	413.0000	12	12		
M7885/2-4-3						**			
Rivet									
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST287	413					
			107376	413					
M7885/3-4-4	Purchased	No	160	Each	108.0000	12	12		
M7885/3-4-4						**			
Rivets									
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST287	108					
			108077	108					
MS20392-2G17	Purchased	No	160	Each	173.0000	2	2		
MS20392-2G17						**			
PIN									
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			ST333	173					
			18949	173					

NOV 29 2014 DAS 06 9-09

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Work Order ID: 117748

117748

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

MS20392-2C9 Purchased No

160 Each 8.0000 2 2

MS20392-2C9

**

M130325

Pin

Location

Loc Qty

Loc Code

ST333

8

11784

5

120521

3

DAS
06
9-09

MS20392-3C21 Purchased No

160 Each 16.0000 2 2

MS20392-3C21

**

PIN

Location

Loc Qty

Loc Code

ST333

16

124296

16

DAS
06
9-09

MS20426AD3-3 Purchased No

160 Each 6,262.000 8 8

MS20426AD3-3

**

RIVET

Location

Loc Qty

Loc Code

ST334

428

123352

428

ST553

5834

M128754

5834

DAS
06
9-09

MS20426AD4-5 Purchased No

160 Each 1,207.000 4 4

MS20426AD4-5

**

RIVET

Location

Loc Qty

Loc Code

ST334

1207

6874

207

m125807

1000

DAS
06
9-09

1106 06 AUN

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Work Order ID: 117748

117748

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

160

Each

5,857.000

6

6

MS21042L08

Nut

Location

Loc Qty

Loc Code

ST314

3558

123900

58

m128401

1500

m128429

2000

ST508

2200

125445

802

m127410

1398

ST509

99

m127304

99

MS21042L4

Purchased

No

160

Each

7,800.000

4

4

MS21042L4

Locknut

Location

Loc Qty

Loc Code

ST314

64

m126015

12

m126275

52

ST509

7725

m127255

71

m127813

994

m128300

1660

m128798

5000

ST518

11

m127376

11

DAS
06
9-09

NOV 29 2014 DAS
06
9-09

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Work Order ID: 117748

117748

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

MS241072-L3 Purchased No

160 Each 230.0000 4 4

MS241072-L3

Nutplate

Location

Loc Qty

Loc Code

ST318

230

121047

20

125535

210

MS24665-151 Purchased No

160 Each 424.0000 6 6

MS24665-151

Cotter Pin

Location

Loc Qty

Loc Code

GA

24

17566

24

ST323

400

m128401

400

MS24693-S271 Purchased No

160 Each 563.0000 4 4

MS24693-S271

Screw

Location

Loc Qty

Loc Code

ST301

563

14478

563

MS24694-C5 Purchased No

160 Each 36.0000 4 4

MS24694-C5

Screw

Location

Loc Qty

Loc Code

ST300

36

106815

36

DAS
06
9-89

DAS
06
9-89

DAS
06
9-89

DAS
06
9-89

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Work Order ID: 117748

117748

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

MS24694-S5 Purchased No 160 Each 385.0000 6 6

MS24694-S5

Screw

Location Loc Qty Loc Code

ST302 385

18949 44

19073 341

DAS
66
9-09

6

MS24694-S50 Purchased No 160 Each 594.0000 18 18

MS24694-S50

Screw

Location Loc Qty Loc Code

ST302 576

m128401 76

m129022 500

ST303 18

m127831 18

DAS
66
9-09

MI30356

MS24694-S98 Purchased No 160 Each 136.0000 4 4

MS24694-S98

Screw

Location Loc Qty Loc Code

ST303 136

125578 26

m128228 10

m128606 100

DAS
66
9-09

4

MS27039-1-05 Purchased No 160 Each 42.0000 2 2

MS27039-1-05

SCREW

Location Loc Qty Loc Code

ST305 42

124555 42

DAS
66
9-09

2

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Work Order ID: 117748

117748

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-06 Purchased No 160 Each 803.0000 14 14

MS27039-1-06
Screw

DAS
06
9-89

Location Loc Qty Loc Code

ST305 803
104289 803

14
13

MS27039-1-08 Purchased No 160 Each 2,111.000 13

MS27039-1-08
Screw

Location Loc Qty Loc Code

GA 19
m125654 19
ST305 2092
m128636 2092

13

DAS
06
9-89

MS35275-233 Purchased No 160 Each 63.0000 2 2

MS35275-233
Screw

Location Loc Qty Loc Code

ST289A 63
103641 20
11822 43

2

DAS
06
9-89

MS35649-264 Purchased No 160 Each 53.0000 2 2

MS35649-264
Nut

Location Loc Qty Loc Code

ST289A 53
11822 53

2

DAS
06
9-89

NOV 29 2014

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Work Order ID: 117748

117748

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

MS35650-3252

Purchased

No

160

Each

34.0000

2

2

MS35650-3252

Nut

Location

Loc Qty

Loc Code

ST289A

34

110372

34

2

MS51859-7

Purchased

No

160

Each

75.0000

2

2

MS51859-7

Washer

Location

Loc Qty

Loc Code

ST290

75

123482

8

M127993

67

2

DAS
06
9-69

NAS1149D0316J

Purchased

No

160

Each

1,048.000

15

15

NAS1149D0316J

Washer

Location

Loc Qty

Loc Code

ST293

648

M127993

648

ST510a

400

M127956

400

6

DAS
06
9-69

NAS1149D0332J

Purchased

No

160

Each

5,569.000

18

18

NAS1149D0332J

Washer

Location

Loc Qty

Loc Code

ST294

569

m128606

569

ST510a

5000

m128612

5000

DAS
06
9-69
NOV 29 2014

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Work Order ID: 117748

117748

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0416J

Purchased

No

160

Each

494.0000

6

6

NAS1149D0416J

WASHER

Location

Loc Qty

Loc Code

GA

119

m126254

119

ST293

300

m129022

300

ST294

75

m125773

11

m127832

64

DAS
G6
9-89

NAS1149DN832J

Purchased

No

160

Each

3,062.000

6

6

NAS1149DN832J

Washer

Location

Loc Qty

Loc Code

MF4

808

M127255

808

ST293

2092

M128948

1000

M127813

92

M128429

1000

st510

145

124555

145

ST510a

17

M126319

17

DAS
G6
9-89

NAS43DD3-10

Purchased

No

160

Each

47.0000

7

7

NAS43DD3-10

SPACER

Location

Loc Qty

Loc Code

ST275

47

19185

9

19347

38

NOV 29 2014

AS
J
-89

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Work Order ID: 117748

117748

Parent Item: D412-694-01

D412-694-01

Parent Item Name: Door Assembly, LH

Start Date: 5/1/2014

Required Date: 9/22/2014

Start Qty: 1.00

Required Qty: 1.00

NAS43DD3-14

Purchased

No

120

Each

76.0000

6

6

~~*NAS43DD3-14*~~

**

Spacer

Location

Loc Qty

Loc Code

ST275

76

113368

40

19347

36

NOV 29 2014

DAS
85
9-89

MS 20426AD4-6

A.P.

14.12.17

x 4

128812 x 4
14.12.17

14.12.17